

Deutz Fahr TTV 6160 750-00481-01 Assembly Instructions

CUSTOMER:	SDF	PART No.	750-00481-01	PART DESCRIPTION:	DF TTV 6160	DOCUMENT NUMBER:	OI 588
-----------	------------	----------	---------------------	-------------------	--------------------	------------------	---------------

Deutz Fahr TTV 6160 750-00481-01 Assembly Instructions

1. Scope

The scope of this procedure is to ensure all DF TTV 6160s are assembled and packaged correctly.

2. Purpose

The purpose of this procedure is to outline the steps necessary in the assembly and packing of DF TTV 6160s.

3. Responsibility

It is the responsibility of the operators to ensure the safety of themselves and others, and quality procedures for the product are followed. It is the responsibility of the Team Leader to ensure these instructions are followed.

4. Corrective action:

If a defect or mistake is found, the Team Leader and/or Quality Engineer should be informed immediately. Operators cannot in isolation, decide how an error is to be rectified.

5. Training

All relevant operators should be trained against this OI. Each operator must sign a T9 – staff training record at point of training.



IMPORTANT: Please be aware that the failure to follow these Operator Instructions can lead to a workplace investigation which may result in the company disciplinary procedure been invoked up to and including dismissal. This is in line with company disciplinary procedures.

Please adhere to COVID 19 prevention measures by practising adequate social distancing whilst carrying out this process, wipe down shared tools and equipment before and after use and ensure good hand hygiene and cough/sneeze etiquette where appropriate.

“It is recommended that daily briefing documents such as SSWP’s, SPA’s, Daily Safe Starts, Task Briefings or equivalent should be updated to reference COVID-19 and specifically social distancing and hand hygiene.”

Ref: Sect. 2, CIF SOP for Covid 19;

REVISION:	A								AUTHOR:	Robert Lowe	SHEET No. 1 of 9
ISSUE DATE:	21/07/21								CHECKED BY:	Mick Lynch	
CHANGE No.:	N/A								APPROVED BY:	Conor Lynch	

Deutz Fahr TTV 6160 750-00481-01 Assembly Instructions

CUSTOMER:	SDF	PART No.	750-00481-01	PART DESCRIPTION:	DF TTV 6160	DOCUMENT NUMBER:	OI 588
-----------	------------	----------	---------------------	-------------------	--------------------	------------------	---------------

Do NOT attempt to carry out this procedure without prior training

Ensure correct PPE is worn at all times.

Ensure hoist and lifting gear is in good working order.

Operators must be trained on:












- SSWP13 – Safe System of Work for Hoist operation procedure
- SSWP28 – Safe System of Work for Phase 2 Final Assembly & Packing area

Title: Safe System of Work for working in Phase 2 Final Assembly and Packing area Location: Phase 2 Rev: Issue Date: 01/01/2017 Last Reviewed:	SSWP28 Rev: A Author: Dave Spiller Approved by: Mick Lynch Machine number: 0812
---	--

WARNING: Only trained personnel should use this machine/equipment.

IMPORTANT:

- The Operator is responsible for the safety of others when operating this equipment.
- DO NOT operate any machines unless you have completed the appropriate operational training and Manual Handling training.
- Report any damage to the dept. supervisor and do not operate the equipment.
- The Operator shall comply with their duties under section 13 of the Safety, Health and Welfare at Work Act 2005 whilst operating this equipment.
- Only Authorised personnel may carry out maintenance on this equipment.

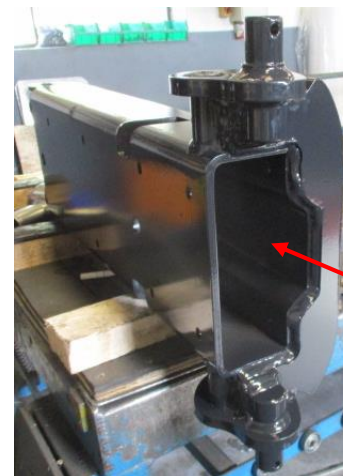
Description of Work:	Working in PHASE 2 FA/Packing area						
  	<p>Learning outcome- Know the Potential Hazards:</p> <ol style="list-style-type: none"> 1. Know where the EMERGENCY STOP is and how to stop all relevant machinery in an Emergency. 2. Beware of pinching fingers when loading/unloading parts. 3. Personal injury: Possible back strain, crushing, fractures, entrapment or major injury. <p>When packing parts:</p> <ol style="list-style-type: none"> 4. Uneven load: Never lift outside of the load weight distribution centre. 5. Never use the hoist to lift, support, or transport people. 6. Never raise or stand under loads. 7. Lift and lower parts as safely and efficiently as possible. 8. Stay clear of loads at all times. 9. Part being lifted must be in front of operator and path must be kept clear. 10. Keep walk ways clear to allow easy access. 11. Never stack boxes on top of each other to a great height. 12. Keep area clean and tidy at all times. 13. Replace tools and equipment in their correct location after each use. 						
<p>Personal Protective Equipment (PPE) Required (Check the box for required PPE)</p>							
 Goggles	 Foot Guards	 Ear Protection	 Respiratory Mask	 Appropriate Harness	 Bump Cap	 Working Gloves	 Personal Fall Protection
<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>	<input checked="" type="checkbox"/>

Refer to the Safe Work Procedure Checklist below:

Station 1



1.) Place the board onto the assembly line, ensuring a clear work area.



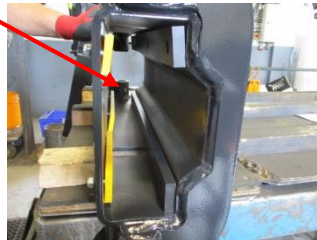
2.) Using the hooked hoist, pick the base off the line.

REVISION:	A								AUTHOR:	Robert Lowe	SHEET No. 2 of 9
ISSUE DATE:	21/07/21								CHECKED BY:	Mick Lynch	
CHANGE No.:	N/A								APPROVED BY:	Conor Lynch	

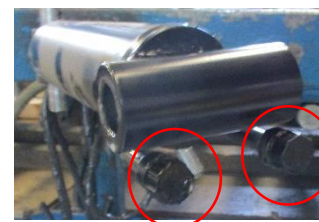
Deutz Fahr TTV 6160 750-00481-01 Assembly Instructions

CUSTOMER:	SDF	PART No.	750-00481-01	PART DESCRIPTION:	DF TTV 6160	DOCUMENT NUMBER:	OI 588
-----------	------------	----------	---------------------	-------------------	--------------------	------------------	---------------

3.) Secure the black wear pads to the bottom of the base, add the yellow wear pads with the shorter pads closer to the hitch.



5.) Turn the base onto its flat edge. Retrieve and place the cassette on the board.



6.) Retrieve cylinder, rotate the arm through 90°. Check the threads on the cylinder.

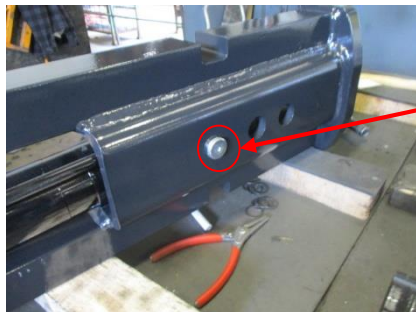


4.) Fasten locknuts to the wear pads with the air gun. Apply **white dot** to base.

REVISION:	A								AUTHOR:	Robert Lowe	SHEET No. 3 of 9
ISSUE DATE:	21/07/21								CHECKED BY:	Mick Lynch	
CHANGE No.:	N/A								APPROVED BY:	Conor Lynch	

Deutz Fahr TTV 6160 750-00481-01 Assembly Instructions

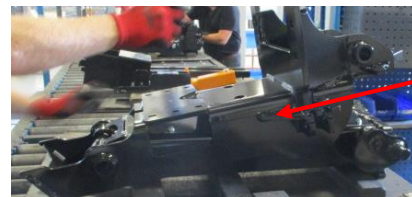
CUSTOMER:	SDF	PART No.	750-00481-01	PART DESCRIPTION:	DF TTV 6160	DOCUMENT NUMBER:	OI 588
-----------	------------	----------	---------------------	-------------------	--------------------	------------------	---------------



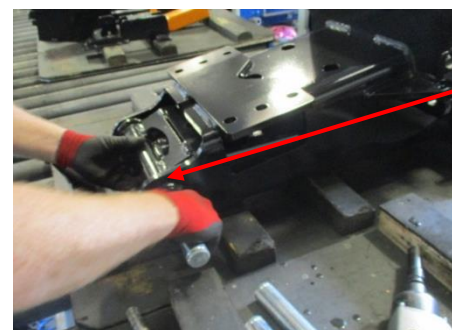
7.) Insert cylinder into cassette, with pipes on bottom. Secure with pin and circlip.



8.) Turn the cassette to it's flat, using the cassette carrier insert cassette into the base.



9.) Position frame above base, lining up the pin holes.



10.) Slide hinge pin through frame, base and cylinder.

REVISION:	A								AUTHOR:	Robert Lowe	SHEET No.
ISSUE DATE:	21/07/21								CHECKED BY:	Mick Lynch	4 of 9
CHANGE No.:	N/A								APPROVED BY:	Conor Lynch	

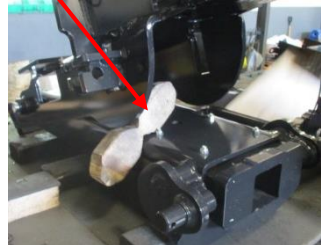
Deutz Fahr TTV 6160 750-00481-01 Assembly Instructions

DROMONE
intelligent:innovation

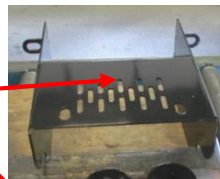
CUSTOMER:	SDF	PART No.	750-00481-01	PART DESCRIPTION:	DF TTV 6160	DOCUMENT NUMBER:	OI 588
-----------	------------	----------	---------------------	-------------------	--------------------	------------------	---------------



11.) Apply warning sticker to frame, place wooden wedge under frame. Fix spring to frame, mark with **white dot**.

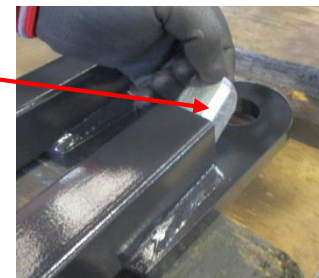


12.) Apply sticker to tow hook, place pin through hook and secure with circlip. Place tow hook and accessories on board.

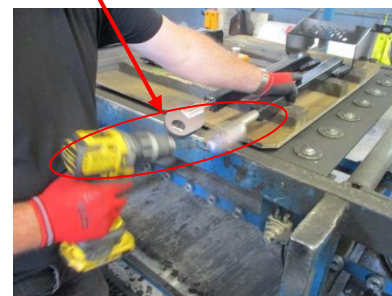
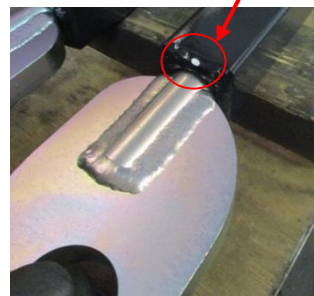


Station 2

13.) Insert nut into top of lift arm. Apply **white dot** when done, this shows the nut is in place.



14.) Slide lift rods through lift arm body, tighten with drill and hook. If the rods move freely mark with **white dot**.



REVISION:	A									AUTHOR:	Robert Lowe	SHEET No.
ISSUE DATE:	21/07/21									CHECKED BY:	Mick Lynch	5 of 9
CHANGE No.:	N/A									APPROVED BY:	Conor Lynch	

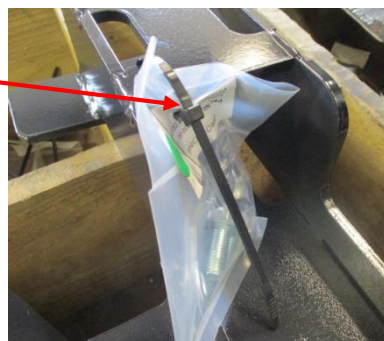
Deutz Fahr TTV 6160 750-00481-01 Assembly Instructions

CUSTOMER:	SDF	PART No.	750-00481-01	PART DESCRIPTION:	DF TTV 6160	DOCUMENT NUMBER:	OI 588
-----------	------------	----------	---------------------	-------------------	--------------------	------------------	---------------

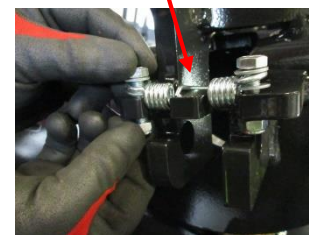
15.) Line up hole in bracket with hole in tab on drawbar pocket. Secure with ring pin. Mark with **white dot**.



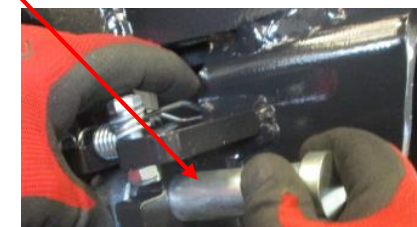
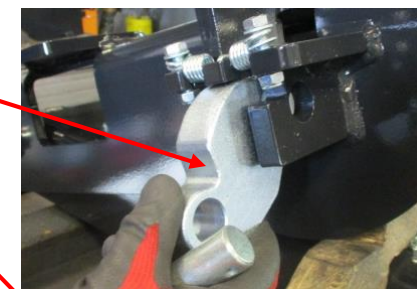
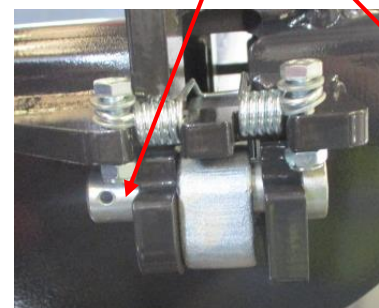
16.) Attach bolt kit to drawbar pocket with cable tie, mark with **white dot** when done.



17.) Position the spring on the frame, place a washer beneath the spring and secure with an additional washer, nut and bolt.



18.) Position latching blocks in place, slide pin through frame and latching blocks.

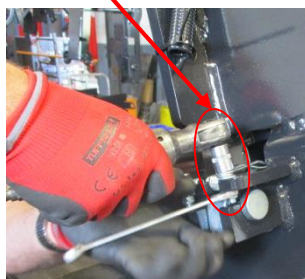
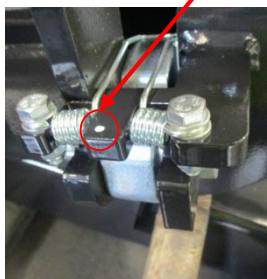


REVISION:	A								AUTHOR:	Robert Lowe	SHEET No.
ISSUE DATE:	21/07/21								CHECKED BY:	Mick Lynch	6 of 9
CHANGE No.:	N/A								APPROVED BY:	Conor Lynch	

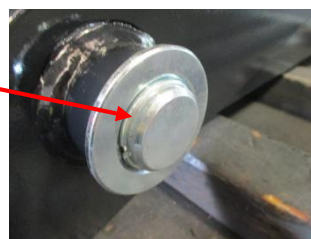
Deutz Fahr TTV 6160 750-00481-01 Assembly Instructions

CUSTOMER:	SDF	PART No.	750-00481-01	PART DESCRIPTION:	DF TTV 6160	DOCUMENT NUMBER:	OI 588
-----------	------------	----------	---------------------	-------------------	--------------------	------------------	---------------

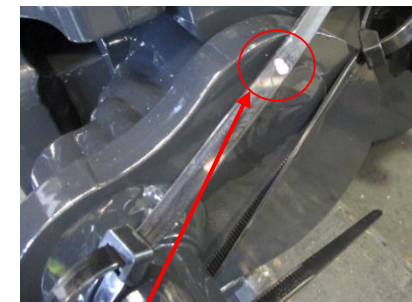
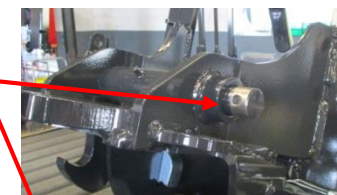
19.) Secure pin with a roll pin. Mark with **white dot** when done. Tighten nut and bolt, mark with **white dot** when done.



20.) Using the slide hammer, secure hinge pin with bevelled washer and circlip. Mark with **white dot**.



21.) Slide latching hook through frame, secure hooks with inner and outer roll pins. Attach cable bracket with nut and bolt. Mark with **white dots** when done.



22.) Attach stickers to frame. Cable tie latching hook to base, mark with **white dot**.

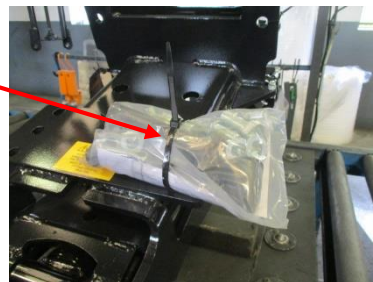
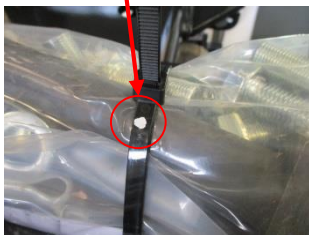


REVISION:	A									AUTHOR:	Robert Lowe	SHEET No. 7 of 9
ISSUE DATE:	21/07/21									CHECKED BY:	Mick Lynch	
CHANGE No.:	N/A									APPROVED BY:	Conor Lynch	

Deutz Fahr TTV 6160 750-00481-01 Assembly Instructions

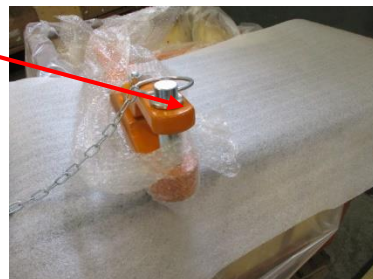
CUSTOMER:	SDF	PART No.	750-00481-01	PART DESCRIPTION:	DF TTV 6160	DOCUMENT NUMBER:	OI 588
-----------	------------	----------	---------------------	-------------------	--------------------	------------------	---------------

23.) Secure bolt kit to frame with cable tie. Mark with **white dot**.

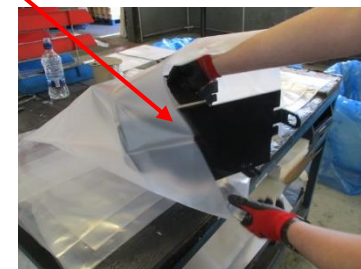


Station 3

24.) Retrieve drawbar from box, place pin through hole, apply sticker and cover in foam wrap.



25.) Place lift links into plastic sleeve, fold in both ends, secure with cable tie. Place accessories into plastic bags.



26.) Place blue plastic liner into crate, using hoist, lower assembly into box.



REVISION:	A								AUTHOR:	Robert Lowe	SHEET No.
ISSUE DATE:	21/07/21								CHECKED BY:	Mick Lynch	8 of 9
CHANGE No.:	N/A								APPROVED BY:	Conor Lynch	

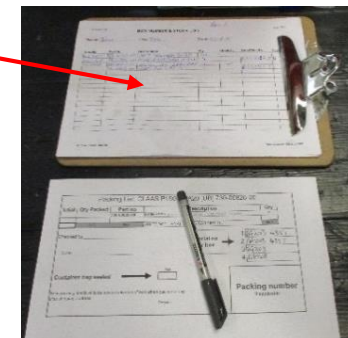
Deutz Fahr TTV 6160 750-00481-01 Assembly Instructions

CUSTOMER:	SDF	PART No.	750-00481-01	PART DESCRIPTION:	DF TTV 6160	DOCUMENT NUMBER:	OI 588
-----------	------------	----------	---------------------	-------------------	--------------------	------------------	---------------

27.) Pack the drawbar first, then lift links, add all accessories. A drawing should be included.



29.) Fill out Box number & stock log, staple address and packing list to box.



28.) Close plastic liner, secure with cable tie. Place lid on box, press in corners with corner tool, hammer down latches.



REVISION:	A								AUTHOR:	Robert Lowe	SHEET No. 9 of 9
ISSUE DATE:	21/07/21								CHECKED BY:	Mick Lynch	
CHANGE No.:	N/A								APPROVED BY:	Conor Lynch	